

Work Order ID 83420

83420

Page 1

April-18-12 8:10:56 AM

Item ID: D3213-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Door Panel

Stop *NS2*

Start Date: 18/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3213

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2024.063

B
B

B12-4-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/24/13

(NO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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10

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10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Debur								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

⑩ MG 12.4.24

M-A
10x ✓ 12/4/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door Panel

Stop

NS2

Start Date: 18/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location **232A**

0.00

160

Packaging

Memo

0.00

Packaging

100

014638

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/4/24

MF
12-04-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-18-12 8:11:00 AM

Page 1

Work Order ID: 83420

83420

Parent Item: D3213-3

D3213-3

Parent Item Name: Door Panel

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now on Waterjet 07-02-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	399.9000	0.4714	4.962105	5		

M2024T3S 063

2024-T3 .063 sheet

**

B12-4-21

Location

Loc Qty

Loc Code

MAT022

399.9

119916

159.9

121197

240

119916

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NOTE: Date & initial all entries

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83420 MJS
12/04/18

RELEASED
2011-06-14

D3213-041 DOOR PANEL ASSY

D3213-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3213
TITLE DOOR ASSEMBLY
REV. B
SHEET 1 OF 4
SCALE
NTS

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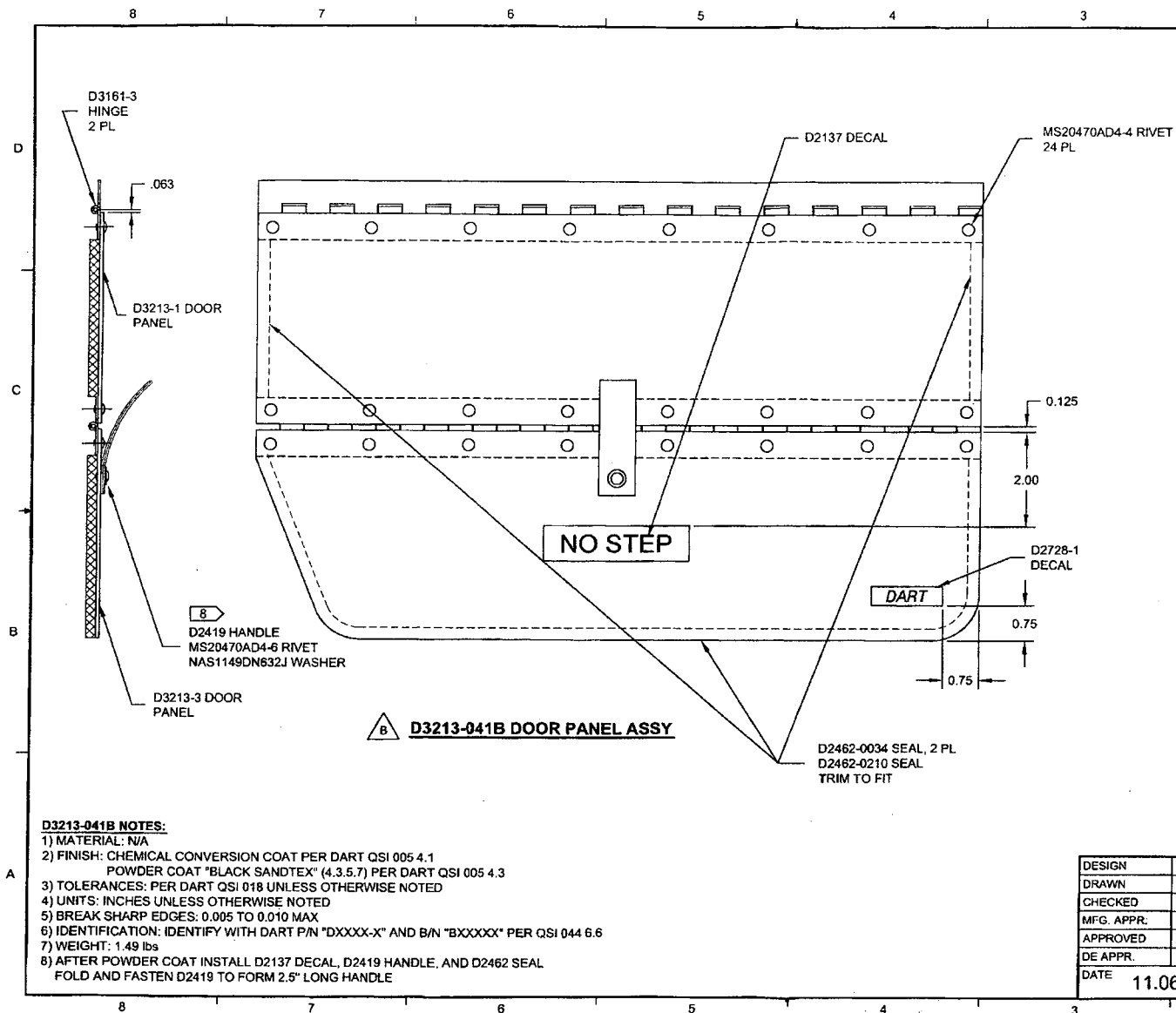
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY	PART NUMBER	DESCRIPTION
-041B		
X	D3213-041B	DOOR ASSEMBLY, BLANK
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D7137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

83420

RELEASED
2011-06-14

D3213-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

B D3213-041B DOOR PANEL ASSY

DESIGN	9P	DART AEROSPACE LTD
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	DRAWING NO. D3213 REV. B
MFG. APPR.	CP	SHEET 2 OF 4
APPROVED	CP	TITLE SCALE
DE APPR.	CP	DOOR ASSEMBLY NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

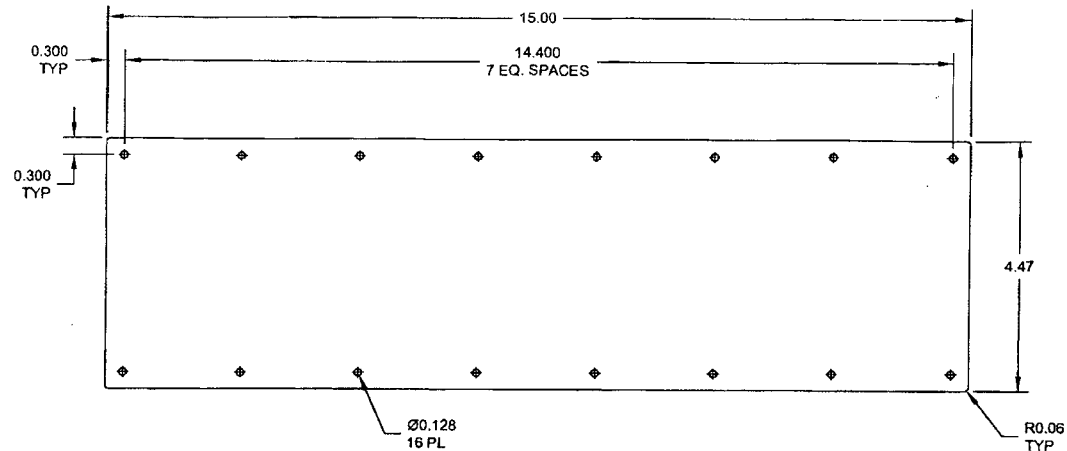
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83420



D3213-1 DOOR PANEL

RELEASED
2011-06-16
JNT

D3213-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JP	D3213	SHEET 3 OF 4
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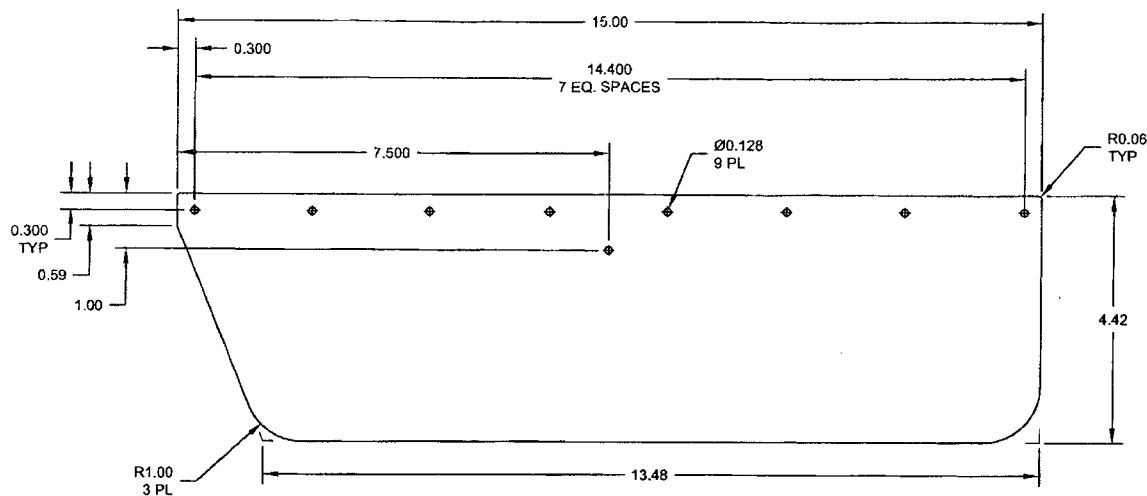
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NOTE: Date & initial all entries

83420



D3213-3 DOOR PANEL

RELEASED
2011-06-10

D3213-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. B
MFG. APPR.	DP	D3213	SHEET 4 OF 4
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